

Date: Tuesday, 04/11/2008 11:19:16 AM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE		
Job Number	43188			Part Number	: D29391		
Estimate Number	10836			Drawing Number	: D2939 REV C		
P.O. Number				Project Number	: N/A		
This Issue	04/11/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	MACHINED PARTS	Due Date	: 20/11/2008		
Previous Run	41715			Qty:	10		
Written By				Um:	Each		
Checked & Approved By	<u>JUL 08/11/09</u>						
Comment	Est: B00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM						
Additional Product							
Job Number: 							
Seq. #:	Machine Or Operation:	Description :					
1.0	D6101001	Saddle Billet 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <u>D34872 (x6) B34701 (x3)</u> mmf 08/11/09 (8)							
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 					
Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet. 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr mmf 08/11/10 (8)							
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 					
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet mmf 08/11/10 (8)							
4.0	QC1	INSPECT ALL DIM TO DIM SHEET 					
Comment: INSPECT ALL DIM TO DIM SHEET mmf 08/11/10 (8)							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2939-1
 (D206-642-311/411/513) PAR #: N/A Fault Category: Proc - Mach NCR: Yes No DQA: H Date: 08.11.13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: H Date: 08/11/20

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/10	2.0	SKID bolt chamber was machined. To low in part RC. forgot to change second geometric offset after tool re-measure. Huge operator error.	H	Scrap, destroy, & replace. no Replace no mit.	MW 08/11/10	Scrap 08/11/10	H	H

NOTE: Date & initial all entries

Date: Tuesday, 04/11/2008 11:19:16 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 43188

Part Number: D29391

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

MF 08/11/10

(8)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(8X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF 08/11/11

7.0 POWDER COATING

POWDER COATING



M-109152

(8)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:30

OVEN TEMPERATURE:

320°

FINISH TIME:

12:00

FL 08/11/11

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JL

Comment: INSPECT POWDER COAT

MF 08-11-11 (8)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 430

SS 08/11/12 (8)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/12 (8)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43188
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.117	.115	.116	.115		
B	0.100	0.140		.113	.110	.110	.111		
C	0.100	0.140		.124	.123	.123	.125		
D	0.210	0.230		.221	.221	.218	.216		
E	1.245	1.255		1.249	1.248	1.248	1.248		
F	1.245	1.255		1.249	1.248	1.248	1.248		
G	2.495	2.505		2.501	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.576	1.576	1.576		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262		.260	.260	.260	.260		
L	0.312	0.317		.315	.314	.314	.315		
M	0.235	0.240		.237	.237	.237	.238		
N	0.100	0.140		.111	.111	.112	.111		
O	0.540	0.560		.544	.544	.544	.544		
P	0.490	0.510		.503	.504	.505	.505		
Q	3.715	3.725		3.717	3.719	3.719	3.719		
R	2.720	2.760		2.740	2.739	2.740	2.739		
S	0.240	0.270		.252	.246	.250	.250		
T	0.100	0.180		.136	.132	.131	.131		
U	1.625	1.635		1.629	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.368	1.368	1.368		
W	0.316	0.321		.320	.320	.321	.321		
X	1.250	1.270		1.265	1.260	1.263	1.263		
Y	1.565	1.585	DT8695 A/B	1.574	1.581	1.580	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	mmj
Date:	08/11/10

Audited by:	<i>John</i>
Date:	08/11/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JK</i>	<i>JK</i>

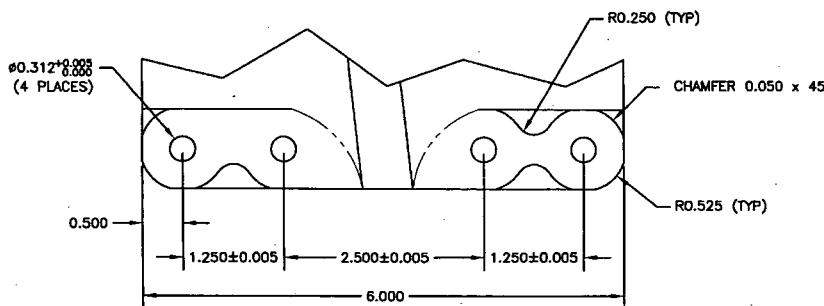
DART AEROSPACE LTD	Work Order:	43188
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.100	0.140		.117	.115	.115	.118		.113
B	0.100	0.140		.111	.111	.119	.119		.116
C	0.100	0.140		.121	.123	.123	.125		.128
D	0.210	0.230		.218	.216	.218	.215		.216
E	1.245	1.255		1.249	1.249	1.250	1.249		1.249
F	1.245	1.255		1.249	1.250	1.249	1.249		1.249
G	2.495	2.505		2.500	2.500	2.500	2.501		2.500
H	0.510	0.515		.515	.511	.512	.512		.512
I	1.572	1.582		1.575	1.575	1.575	1.575		1.575
J	2.495	2.505		2.498	2.498	2.498	2.498		2.498
K	0.257	0.262		.260	.260	.260	.260		.260
L	0.312	0.317		.314	.314	.314	.314		.314
M	0.235	0.240		.238	.237	.238	.237		.237
N	0.100	0.140		.111	.107	.110	.109		.110
O	0.540	0.560		.548	.542	.545	.543		.542
P	0.490	0.510		.504	.505	.508	.508		.505
Q	3.715	3.725		3.717	3.717	3.717	3.717		3.717
R	2.720	2.760		2.743	2.742	2.741	2.741		2.746
S	0.240	0.270		.250	.253	.253	.253		.253
T	0.100	0.180		.131	.131	.131	.131		.130
U	1.625	1.635		1.629	1.629	1.629	1.629		1.630
V	1.362	1.372		1.366	1.367	1.365	1.366		1.366
W	0.316	0.321		.320	.320	.320	.320		.320
X	1.250	1.270		1.243	1.256	1.258	1.258		1.262
Y	1.565	1.585	DT8695 A/B	1.576	1.575	1.577	1.572		1.577
Z	0.178	0.198		.188	.188	.188	.188		.188
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

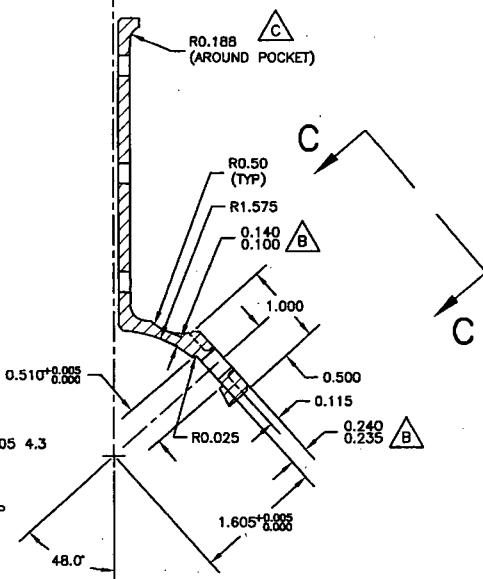
Measured by:	mrf	Audited by:	cmz
Date:	08/11/10	Date:	08/11/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	cmz



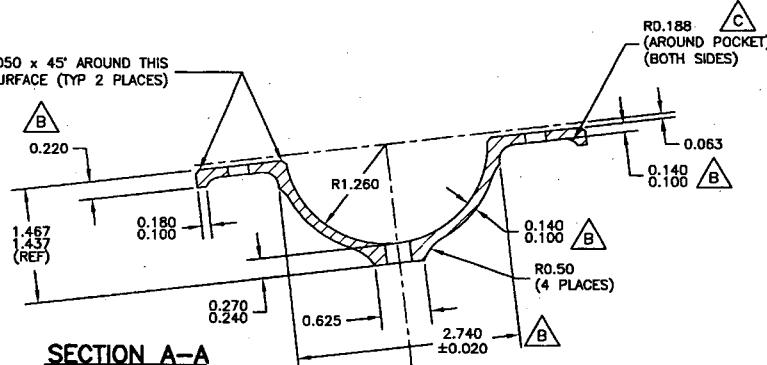
VIEW C-C

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

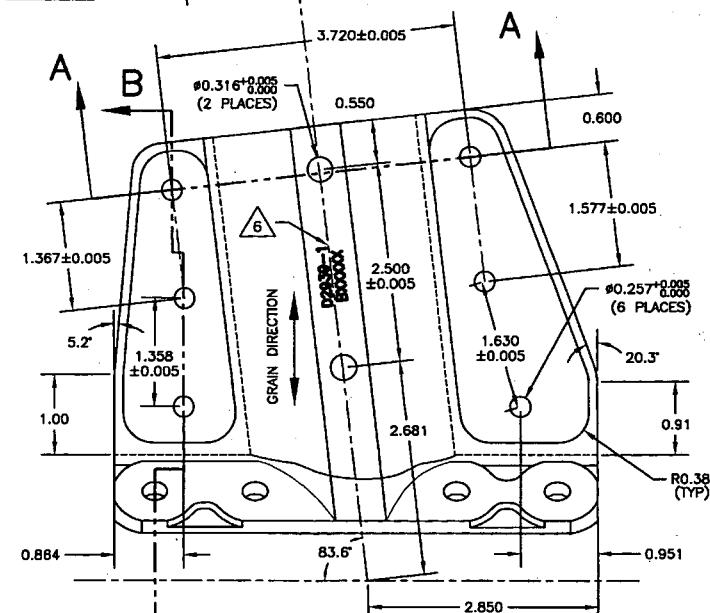


SECTION B-B

CHAMFER 0.050 x 45° AROUND SURFACE (TYP 2 PLAC)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN 	DRAWN BY 	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED 	APPROVED 	DRAWING NO. D2939 REV. C SHEET 1 OF 1
DATE 06.11.09	TITLE SADDLE INSIDE	SCALE 2:3

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